

Work Order ID 85899

85899

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June-18-12 1:00:14 PM

Item ID: D2596

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Web, 205 Skidtube

Start Date: 18/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/18 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2596 | Rev D | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr | | | | | | | | |
| 110 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

4 0 CF 12-7-12

4 0 12-7-12

4 0 12-07-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 85899***85899***

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June-18-12 1:00:14 PM

Item ID: D2596

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web, 205 Skidtube

Start Date: 18/06/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: **LG**

0.00

130

Packaging

Memo

0.00

Packaging

4 **0** **CF 12-7-12**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS 12/07/12**MCS 12/07/12**

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

June-18-12 1:00:18 PM

Page 1

Work Order ID: 85899

85899

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| D2500-3-100 | | Manufactured | No | | | 100 | Each | 4.0000 | 1 | 4 | | | |
| *D2500-3-100* | | | | | | | | | ** | (4) | | CF 12-7-11 | |
| Ext'n - I' Beam Web 4" | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | LG | | | | 4 | | | | | |
| | | | | | 51957 | | | 2 | | | | | |
| | | | | | 79041 | | | 2 | | | | | |

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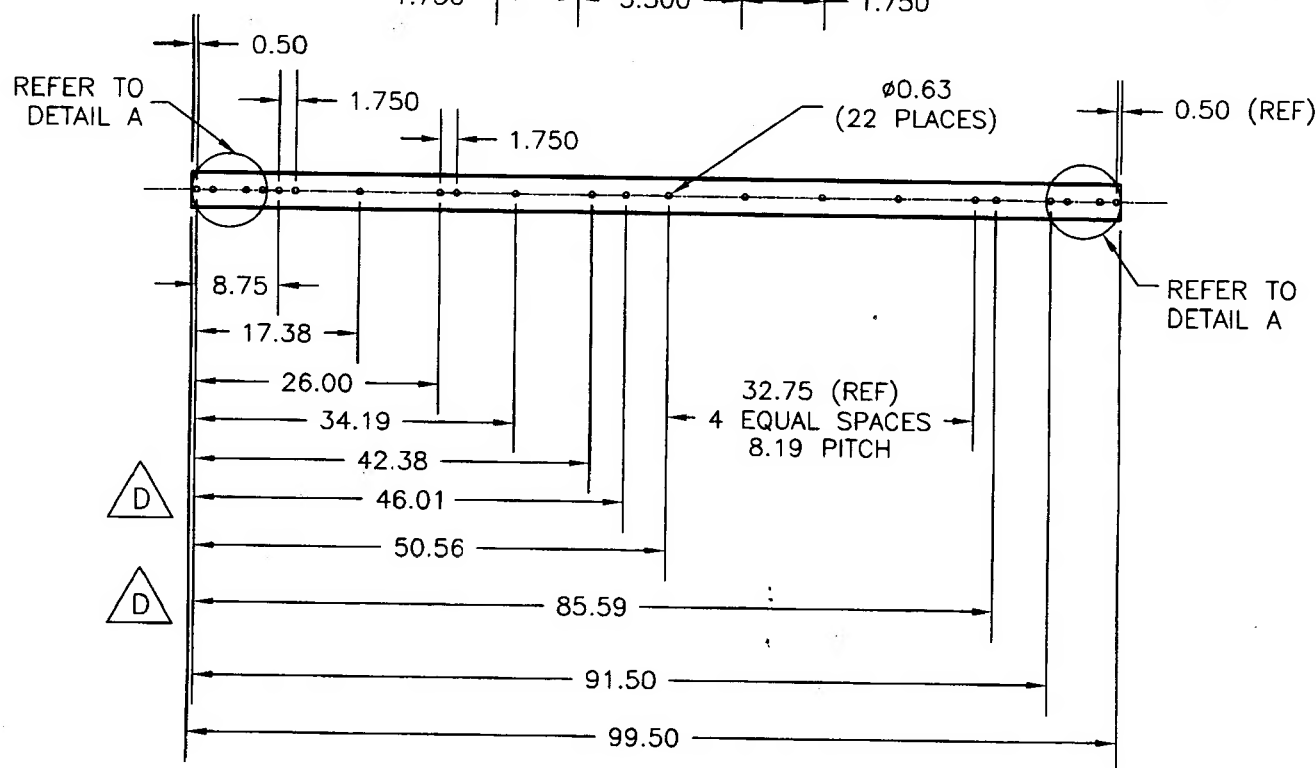
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NOTE: Date & initial all entries



07 Dec 68

NO. 85899 MLJ
12/06/18

Diagram showing the elevation view of a circular structure. A horizontal line is drawn across the circle. Below the circle, four vertical lines extend downwards. The horizontal distance between the first and second vertical lines is 1.750. The horizontal distance between the second and third vertical lines is 3.500. The horizontal distance between the third and fourth vertical lines is 1.750.



- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

| | | | | | |
|---------|---|----------|---|--|--------------|
| DESIGN | 04 | DRAWN BY | 04 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | APPROVED |  | DRAWING NO. | D2596 |
| DATE | 07.04.17 | | | TITLE | 205 WEB |
| A | 96.09.16 | | | NEW ISSUE | |
| B | 97.07.23 | | | Ø0.63 HOLE WAS | Ø0.56 |
| C | 98.09.14 | | | INCORPORATED | DEO 9097 |
| D | 07.04.17 | | | INCORPORATED | DEO 9183 |
| | | | | SCALE | 1:20 |
| | | | | REV. D | SHEET 1 OF 1 |

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